

Date: Monday, 3/19/2007 4:38:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, INBOARD, RS, 206		
Job Number	: 31299		Part Number	: D26662		
Estimate Number	: 10821		Drawing Number	: D2666 REV.D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/19/2007 S.O. No. : N/A		Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/30/2007 Qty: 12 Um: Each		
Previous Run	: 28604					
Written By						
Checked & Approved By						
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No: <u>8230134</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on <u>N/A</u> by <u>N/A</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet 		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		6.00						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07.03.29	2	6.000 dim is 5.984". Blank cut incorrectly, Qty (1) affected	2 07/04/05	Acceptable per attached	DS email	N/A	✓ 07/04/05	CP 07.03.29 PR 05/04/05	✓ 07/04/04

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	31299
Description: 206 Saddle, Inboard, Right side				Part Number:	D2666-2
Inspection Dwg: D2666 Rev. C				Page 1 of 1	

CB 07.03.20

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	0.125	0.121	0.123		
B	0.100	0.140		.137	0.119	0.121	0.124		
C	2.470	2.510		2.4193	2.442	2.443	2.446		
D	0.100	0.180		.145	0.140	0.140	0.140		
E	0.210	0.230		.220	0.218	0.219	0.219		
F	1.313	1.343		1.326	1.323	1.321	1.321		
G	0.240	0.260		.252	0.249	0.249	0.250		
H	0.615	0.685		.660	0.660	0.660	0.660		
I	1.125	1.145		1.137	1.133	1.137	1.136		
J	0.990	1.010		1.009	1.008	1.005	1.006		
K	0.235	0.240		.240	0.236	0.237	0.237		
L	0.510	0.515		.512	0.510	0.510	0.510		
M	0.100	0.120		.115	0.115	0.115	0.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.003	6.001	6.002	6.002		
P	1.245	1.255		1.250	1.249	1.246	1.246		
Q	2.495	2.505		2.500	2.500	2.500	2.498		
R	0.490	0.510		.503	0.495	0.498	0.496		
S	0.313	0.318	DT8686	.315	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.366	1.358	1.361		
V	0.315	0.322	DT8686	.321	0.320	0.320	0.320		
W	0.540	0.560		.550	0.543	0.546	0.546		
X	1.674	1.684		1.679	1.676	1.678	1.679		
Y	0.257	0.262	DT8683	.258	0.259	0.259	0.259		
Z	0.178	0.198		.188	0.189	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BC / SN	Audited by:	SA
Date:	07.03.20	Date:	07.03.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	SA

DART AEROSPACE LTD				Work Order:	31299
Description: 206 Saddle, Inboard, Right side				Part Number:	D2666-2
Inspection Dwg: D2666 Rev. C				Page 1 of 1	

(B 07.03.20)

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 ₉	2 ₁₀	3 ₁₁	4 ₁₂		
A	0.100	0.140		0.123	0.124	0.123	0.124		
B	0.100	0.140		0.126	0.121	0.121	0.121		
C	2.470	2.510		2.494	2.495	2.494	2.493		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.219	0.220	0.221	0.220		
F	1.313	1.343		1.324	1.324	1.324	1.323		
G	0.240	0.260		0.250	0.248	0.251	0.251		
H	0.615	0.685		0.660	0.660	0.660	0.660		
I	1.125	1.145		1.136	1.136	1.137	1.135		
J	0.990	1.010		1.006	1.004	1.006	1.005		
K	0.235	0.240		0.236	0.236	0.236	0.236		
L	0.510	0.515		0.510	0.510	0.510	0.510		
M	0.100	0.120		0.115	0.115	0.115	0.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.002	5.988	6.001	6.001		
P	1.245	1.255		1.247	1.248	1.248	1.248		
Q	2.495	2.505		2.501	2.501	2.499	2.499		
R	0.490	0.510		0.499	0.485	0.494	0.496		
S	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
T	2.495	2.505		2.497	2.503	2.498	2.501		
U	1.357	1.367		1.360	1.360	1.360	1.361		
V	0.315	0.312	DT8686	0.320	0.320	0.320	0.320		
W	0.540	0.560		0.544	0.546	0.546	0.545		
X	1.674	1.684		1.680	1.679	1.681	1.679		
Y	0.257	0.262	DT8683	0.259	0.257	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	En	Audited by:	SJ
Date:	07.03.20	Date:	07.03.20

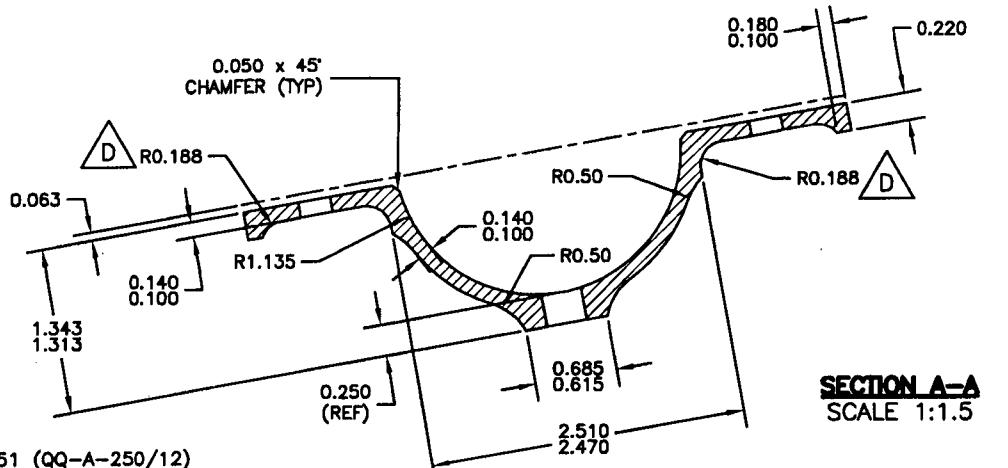
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. D
PH	PH	D2666	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.08		SADDLE FWD INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

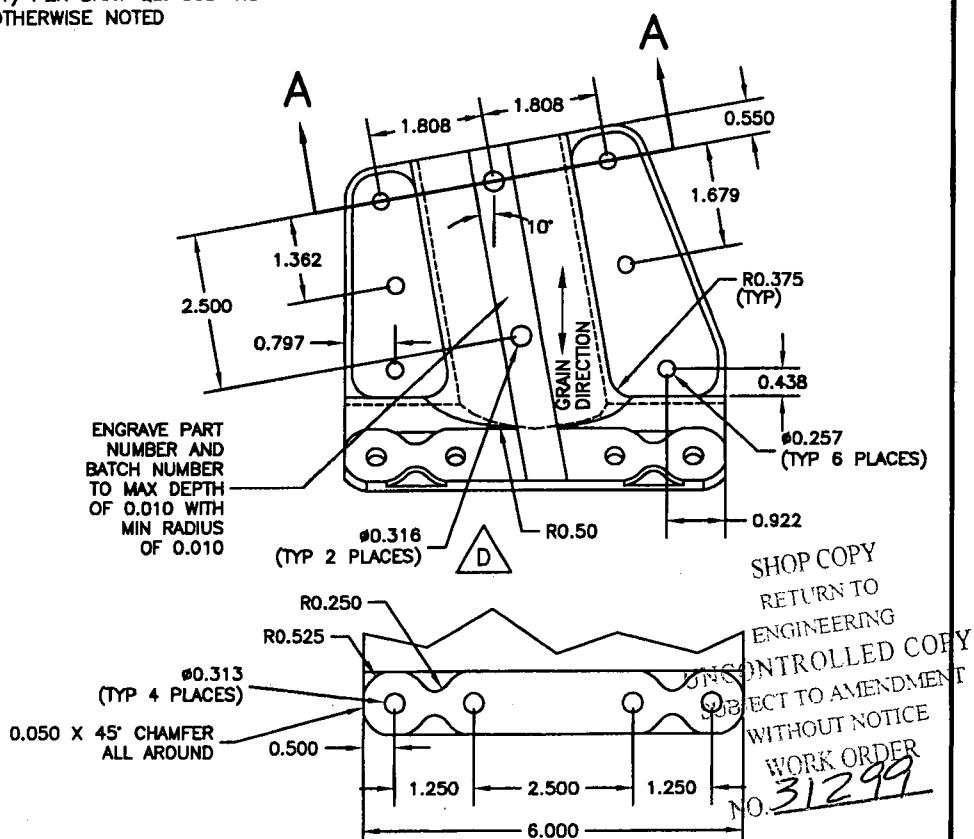
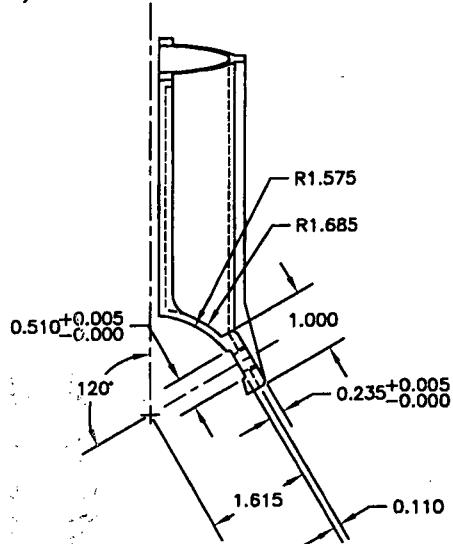
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: March 29, 2007 6:12 PM
To: 'Chris Provencal'
Subject: RE: NCR D2666-2

Acceptable deviation.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, March 29, 2007 1:51 PM
To: David Shepherd (David Shepherd)
Subject: NCR D2666-2

D2666-2

One saddle, the width of the saddle is 5.984" wide instead of 6.000". So the saddle is 0.016" too narrow, or 0.006" under min tolerance. This was due to an error in cutting the blank.

Is this acceptable?

-Chris

--
No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007

--
No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007